

Work Order ID 52226

Monday, September 21, 2009 11:41:21 AM

Page 1

Item ID: D3315-3

Accept

Revision ID: B

Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 6.00

Required Date: 10/2/2009 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 9-9-08



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-9-08

120

0.00



QC8- Inspect parts - second check

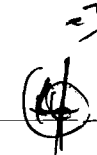
QC

Memo

0.00

Quality Control

27 8/21/08



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Setup Start



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Stop



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
	Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: <i>P SB 09/10/08</i>								
140 QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	Memo	0.00							
150 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
	Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev:								
	<input type="checkbox"/> Qty Part Number Description Batch <input type="checkbox"/> A/R								
	N/A 7560 Hardcoat Rod <i>M109060</i>								

EL 9-10-5

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Item ID: D3315-3

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Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00

2> S 09/10/05

3
89

φ



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

2> S 09/10/05

3
89

φ



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Bl 09-10-06



Powdercoat

Memo

0.00

START TIME: 11:45 □ OVEN TEMPERATURE:

3200 □ FINISH TIME:

12:15

4

Powder Coating

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Page 4

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Start Date: 9/21/2009 Start Qty: 6.00

Required Date: 10/2/2009 Req'd Qty: 6.00





Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	SAD 09-10-05			4			
200  Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-3, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <u>S1496</u>	0.00 0.00	SAD 09-10-05			④			
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/10/07  RD 09-10-7			

Picklist Print

Page 1

Monday, September 21, 2009 11:41:20 AM

Work Order ID: 52226



Parent Item: D3315-3RevB



Parent Item Name: Wearplate


Start Date: 9/21/2009

Required Date: 10/2/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			100	sf	111.6200	14.5011			

B 44-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.62

105706

0.6

111410

111.02

105706

111410

DART AEROSPACE LTD		Work Order: 52224
Description: Wearplate		Part Number: D3315-3
Inspection Dwg: D3315	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

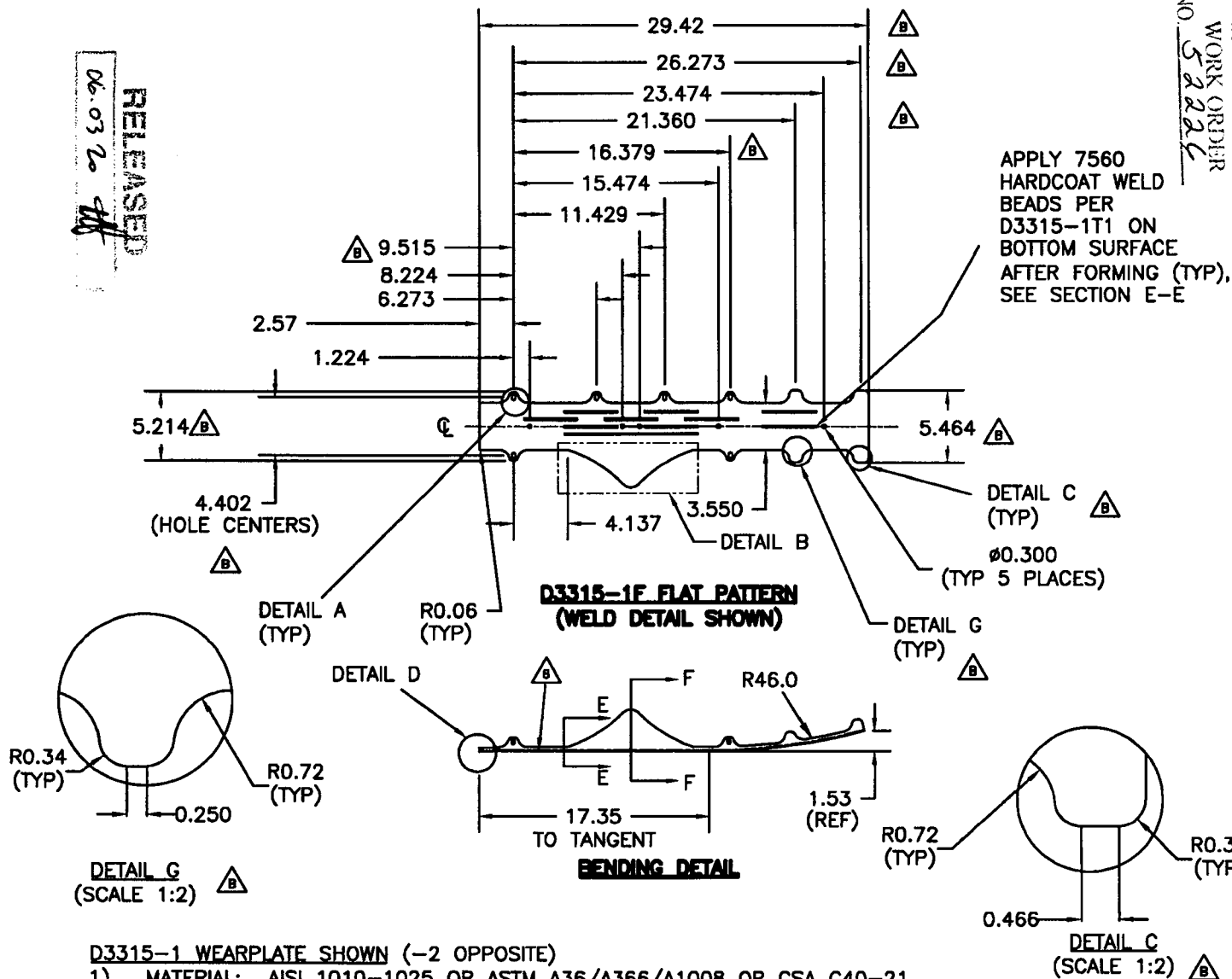
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75	X			
58.094	+/-0.010	58.094	X			
51.368	+/-0.010	51.368	X			
44.531	+/-0.010	44.531	X			
37.719	+/-0.010	37.719	X			
30.375	+/-0.010	30.375	X			
24.188	+/-0.010	24.188	X			
18.875	+/-0.010	18.875	X			
17.375	+/-0.010	17.375	X			
10.594	+/-0.010	10.594	X			
5.375	+/-0.010	5.375	X			
0.875	+/-0.010	0.875	X			
1.62	+/-0.030	1.62	X			
5.214	+/-0.010	5.211	X			
4.402	+/-0.010	4.399	X			
3.550	+/-0.010	3.551	X			
Ø0.300	+0.006/-0.001	0.304	X			
Ø0.266 x 0.450	+/-0.010	0.266 x 0.454	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-23	Date: 09/09/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	

SHOP COPY

ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 5222



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	84	UNKNOWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D3315	SHEET 1 OF 4
DATE				TITLE	SCALE
06.01.31				WEARPLATE	1:12
A		04.09.10		NEW ISSUE	
B		06.01.31		UPDATE DIMENSIONS	

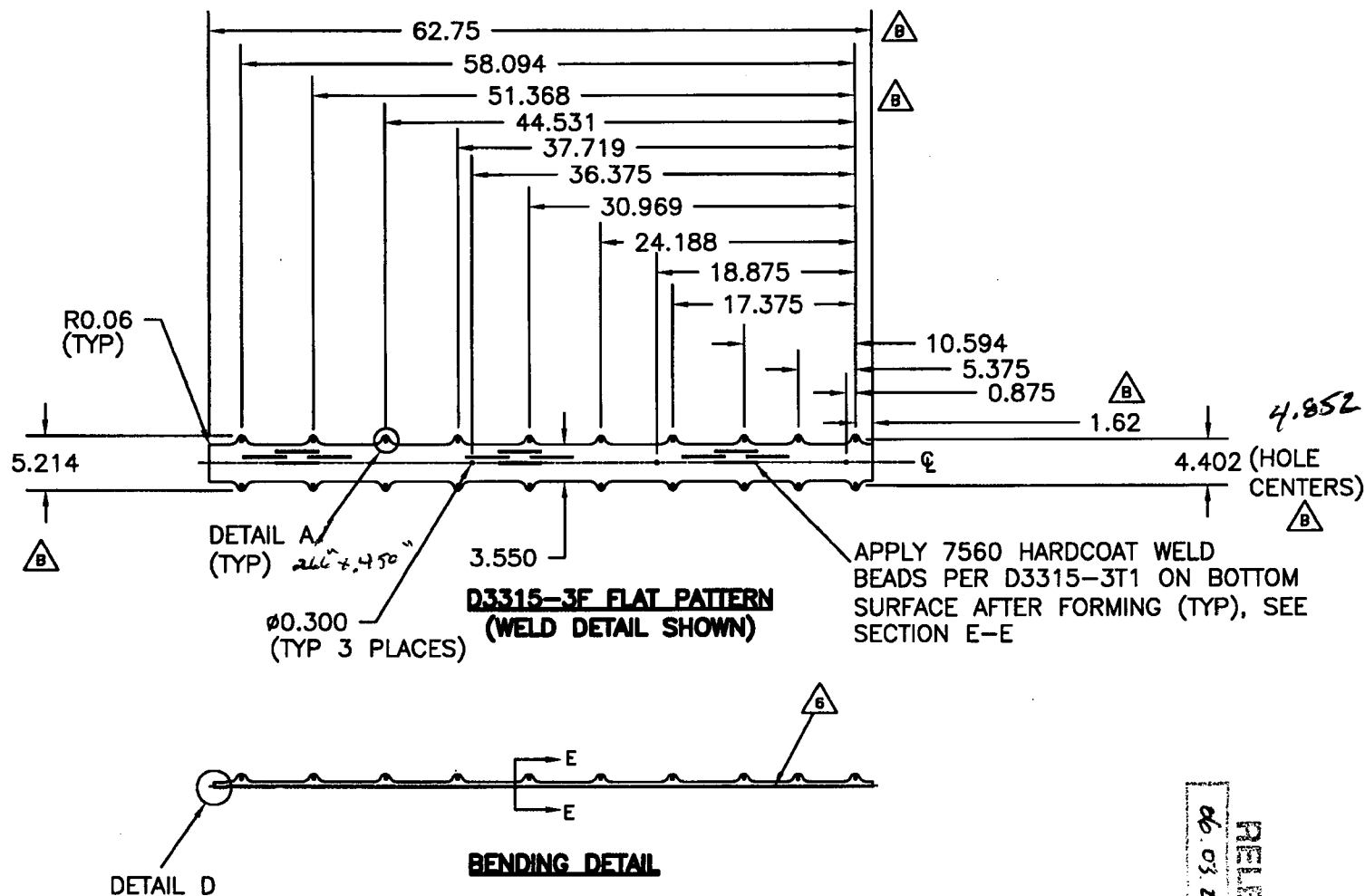
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DART

W/O 52226

**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

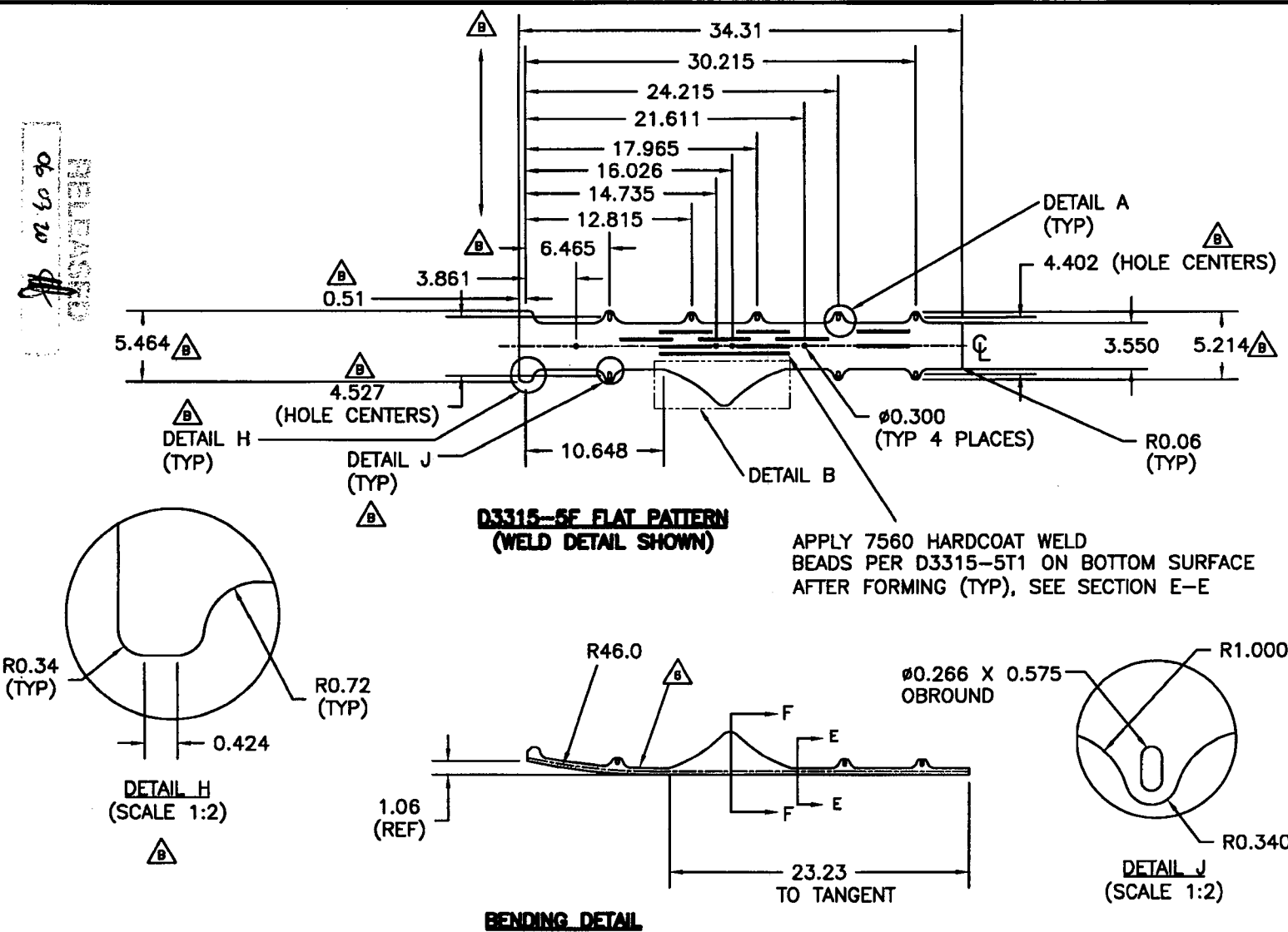
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06.03.20

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CHECKED	PH	APPROVED	PH	
DATE	06.01.31	DRAWING NO.	D3315	REV. B
TITLE	WEARPLATE	SHEET	2 OF 4	SCALE
				1:18

DART

W/O 52224

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
TITLE	WEARPLATE	SHEET 3 OF 4	SCALE	1:12



**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

BENDING DETAIL

D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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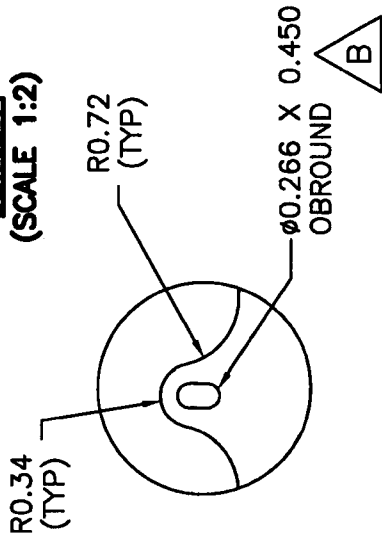
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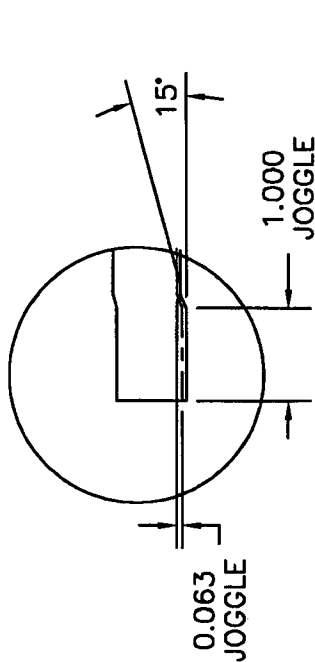
W/O 52226

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DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

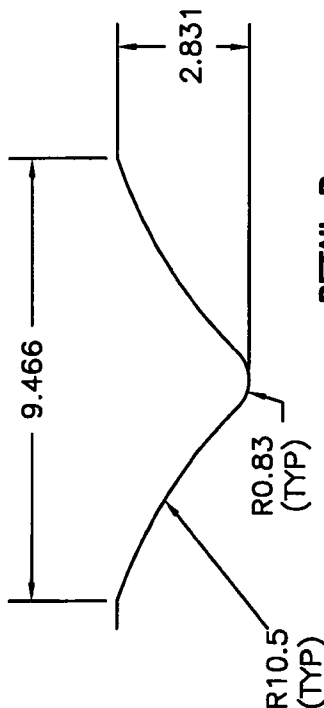
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(SCALE 1:2)



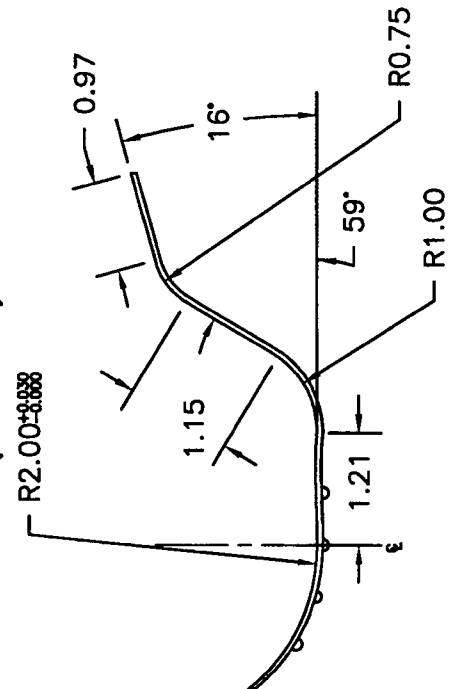
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06.03.20



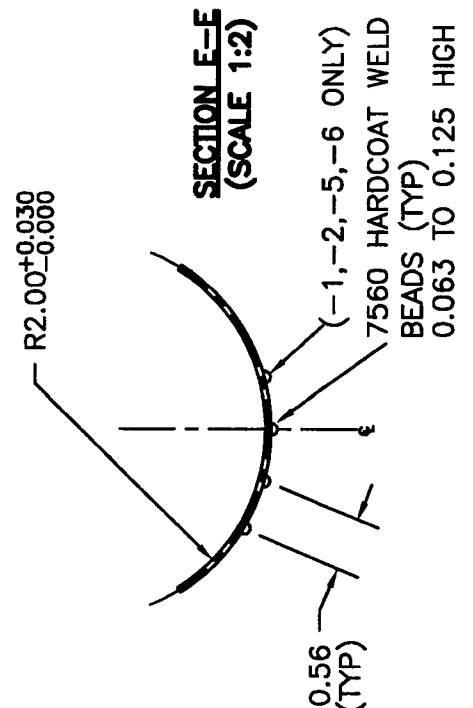
DETAIL D
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)

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